

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019877**Date Inspected:** 14-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Mike Hasler was present during the times noted above for observations relative to the work being performed.

**OBG Segment Name:** 10BW / Bay 14

This Caltrans QA inspector observed Flux Cored Arc Welding (FCAW) in progress. Welder is identified as #045175, welding weld joint #SSD13A-PP98-128 using WPS-B-T-231-TC-U4b-F. ZPMC QC inspectors are identified as Mr. Xu Tao and CWI, Mr. Liu Hua Jie. The welding variables recorded by QC appeared to comply with the WPS.

**OBG Segment Name:** 11DE / Bay 14

This Caltrans QA inspector performed Ultrasonic Testing (UT) verification of the areas previously tested and accepted by ZPMC Quality Control personnel. ZPMC NDT Inspection Notification Document number is identified as #4853. This QA Inspector generated an UT report for this date. The following welds were tested on the inside longitudinal beam joining bottom plate of Segment 11DE. The welds are identified as SEG-072A-005 and SEG072A-020. See Caltrans Ultrasonic Test Report (TL6027), dated 12-14-09 for additional information.

**OBG Segment Name:** Bottom Plate / Bay 19

This Caltrans QA inspector performed Ultrasonic Testing (UT) verification of the areas previously tested and accepted by ZPMC Quality Control personnel. ZPMC NDT Inspection Notification Document number is identified as #4858. This QA Inspector generated an UT report for this date. The following plate splice welds were tested on bottom plate BP025-013-001, BP-025-013-002, BP025-013-003, BP026-013-001, BP-026-013-002 and

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

BP026-013-003. See Caltrans Ultrasonic Test Report, date 12-14-09 for additional information.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

“As noted within the contents of this report.”

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Hasler, Mike	Quality Assurance Inspector
<b>Reviewed By:</b>	Riley, Ken	QA Reviewer

---